

20-8480



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2360

Job Sheet 185497



Part No: D2360

Job Qty: 4 ea

Part Name: Litter Tie Down Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/18

Job Tracking No:

Due Date: 11/16/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining		DTP 18-11-08
100	Bandsaw	4 pcs	11/16/18	11/16/18	0.00	0.13	Bandsaw1		DTP 18-11-08
110	CNC Vertical Machining	4 pcs	11/16/18	11/16/18	0.26	5.97	HAAS 1		DTP 18-11-08
120	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC2		SL 18/11/17
130	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC8		SL 18/11/17
140	HandFinish	4 pcs	11/16/18	11/16/18	0.00	0.31	HandFinish1		DR 18/11/12
150	Powdercoat	4 pcs	11/16/18	11/16/18	0.00	0.24	Powdercoat1		DEC 18/11/13
160	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC3		NOV 13 2018
170	Small Fab	4 pcs	11/16/18	11/16/18	0.00	1.26	Small Fab		SMR DAS
180	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC5		DEC 06 2018
190	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3		DEC 07 2018
200	QC21-SA	4 Ea	11/16/18	11/16/18	0.00	0.00	QC21		9-88

Part Op 100 - Cut blanks: 12.65" Long

Descriptions: 110 - Machine as per Folio D2341 and Dwg D2341

M188857 150 - START TIME: 10:10

170 - Assemble as per dwg D2360

open hole to .246 #10

12.650" ea -> 1,054 ft. each

x 8 pcs

8,432 ft total



Container No: S126231



Part: D2360

Job No: 185497

Serial No/Batch: S126231

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 815 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 11/08/18

Plex 10/29/18 11:32 AM dart.white.jesse

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	4.2160 ft (1.054 ea)	90-Start up Operation	
AN526C1032R18	Screw	4 Ea (1 ea)	170-Small Fab	SO41249
D2002-015	Knob	8 Ea (2 ea)	170-Small Fab	SO41249 X1 SO 41349
D2345	Lock Channel	4 Ea (1 ea)	170-Small Fab	SO69018 X1
D2366	Lock Handle	8 Ea (2 ea)	170-Small Fab	SO114706
D2367	Handle Knob	4 Ea (1 ea)	170-Small Fab	SO41151
D2372	Quick Release	8 Ea (2 ea)	170-Small Fab	SO95300 X2
D2373	Spring	4 Ea (1 ea)	170-Small Fab	SO54946
D2444	Pip Pin Assembly	4 Ea (1 ea)	170-Small Fab	SO81729 X1
MS20470AD3-4	Rivet, Universal Head	4 Ea (1 ea)	170-Small Fab	FM13851-1
MS21042L3	Nut	12 Ea (3 ea)	170-Small Fab	SO94592
MS27039-1-13	Screw	4 Ea (1 ea)	170-Small Fab	SO711833
MS27039-1-15	Screw	8 Ea (2 ea)	170-Small Fab	FM136559.302
NAS1149D0332J	Washer	32 Ea (8 ea)	170-Small Fab	SO100407
NAS1149D0363J	Washer	8 Ea (2 ea)	170-Small Fab	SO95293
NAS679A3W	Nut	4 Ea (1 ea)	170-Small Fab	FM2409X2
				SO131215 X6

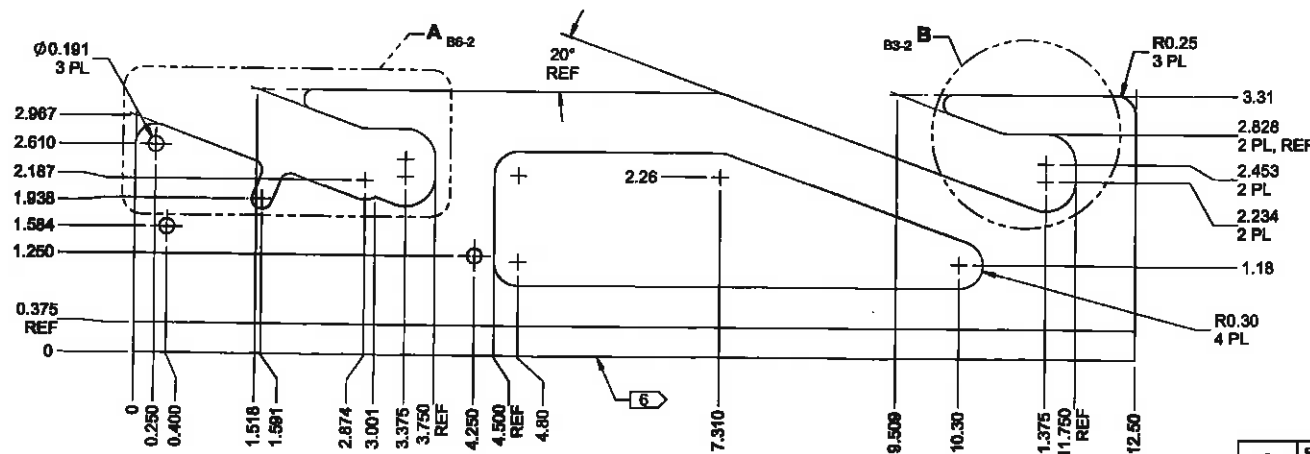
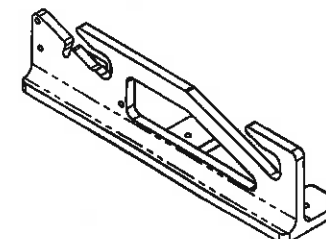
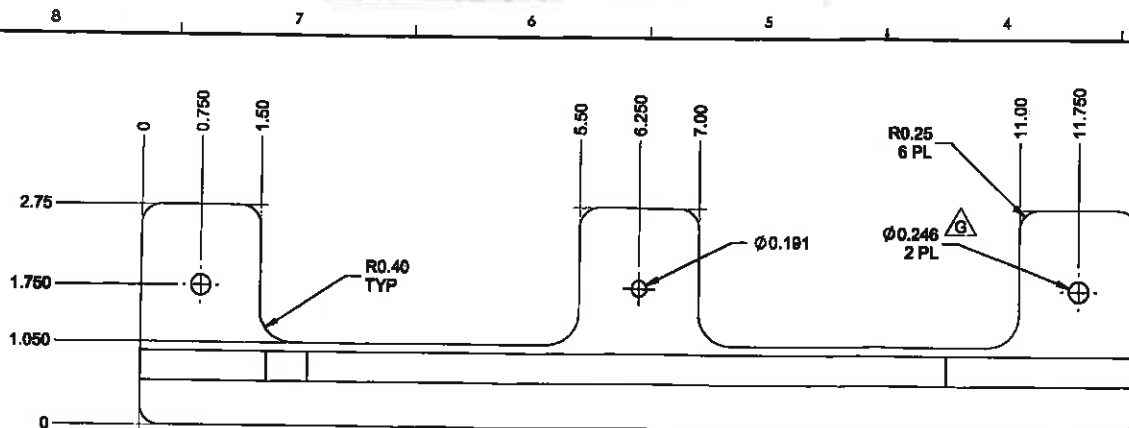
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6201	4	22	0
170-Small Fab	AN526C1032R18	4	91	0
	D2002-015	8	9	0
	D2345	4	9	0
	D2366	8	45	0
	D2367	4	9	0
	D2372	8	2	0
	D2373	4	12	0
	D2444	4	1	0
	MS20470AD3-4	4	6,419	0
	MS21042L3	12	2,373	0
	MS27039-1-13	4	440	0
	MS27039-1-15	8	369	0
	NAS1149D0332J	32	1,940	0
	NAS1149D0363J	8	1,591	0
	NAS679A3W	4	124	0

Part Specifications

Specifications could not be found.

Plex 10/29/18 11:32 AM dart.white.jesse



D2341 LITTER TIE DOWN BRACKET (LOCKING)

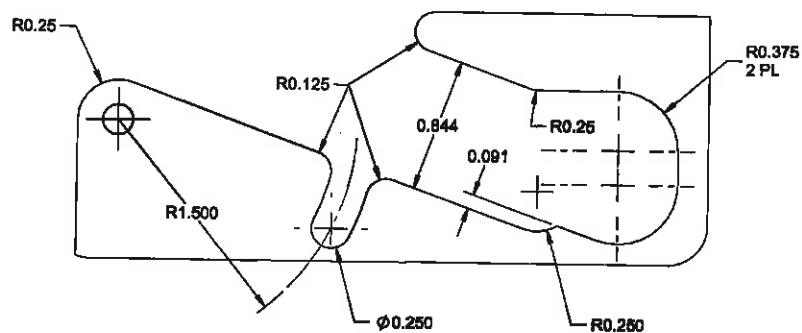
NOTES:

- 1) MATERIAL: MAKE FROM D6201-125 EXTRUSION
REF. 8081-T8/T851 PER QQ-A-200/8
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2341" AND B/N "BXXXXXX" ON BOTTOM FACE PER QSI 044 6.1
- 7) WEIGHT: 1.64 lbs

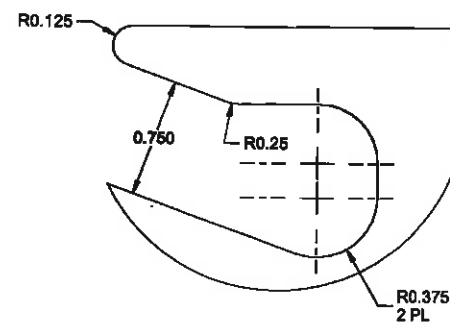
RELEASED
2016-04-18
EDW-BZ

APPROVED

REV.	DESCRIPTION	BY	DATE
G	REFORMAT TO CURRENT STD; Ø0.246 WAS Ø0.242. REASON: PARTS-415.	MB	15.11.12
F	REVISED NOTES; FINISH WAS ANODIZE	DC	07.08.07
E	CHANGES FOR MACHINING	KE	07.10.01
D	CHANGES TO DIAMETERS	KE	06.02.20
B	MODIFIED LOCK	BW	05.02.14
A	NEW ISSUE	BW	05.01.13
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. G
MFG. APPR.	JLM	D2341	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LITTER TIE DOWN BRACKET (LOCKING)	NTS
DATE	15.11.12	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	



DETAIL A C8-1
SCALE 2X



DETAIL B C4-1
SCALE 2X

RELEASED
2016-04-18

APPROVED

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. G
MFG. APPR.	JLM	D2341	SHEET 2 OF 2
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 2R Date: SEP 17 2020Work Order update only ☐

Work Order: <u>185497</u> Part No. <u>02341</u> NCR No. <u>22-8480</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☒ Suspected Unapproved ☒		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☒</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : <u>18-11-07</u>		Step #: <u>110</u>		QTY Effective : <u>① + ①</u>		MRB (QSI042) Approval DAS 9 9-89 <u>18-11-07</u>																																																																	
Description Work Order Deviation <u>① 1.50 (±) .03 measurement is 1.462 = .008" under minimum measurement</u> <u>② holes in wrong spot (scrap)</u>				Disposition <u>Shorten tool to eliminate vibrations</u> <u>Part is acceptable</u> DAS 9 9-89		Completed By <u>SC 18/11/07</u> Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>18-11-07</u> QC / QA Coordinator Approval DAS 9 9-89 <u>18-11-07</u>																																																																	
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